

Date: Tuesday, 10/06/2008 12:54:35 PM  
 User: Julie Lecocq

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: OUTER FWD SADDLE
Job Number	: 39793		
Estimate Number	: 11076		
P.O. Number	:	Part Number	: D5951
This Issue	: 10/06/2008 S.O. No. :	Drawing Number	: D5951 REV.B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : MACHINED PARTS	Drawing Revision	: B
Previous Run	: 39603	Material	:
Written By	:	Due Date	: 30/06/2008
Checked & Approved By	: <u>JULIE 08.10.10</u>	Qty:	12 Um: Each
Comment	: Est Rev:E Re-Format 05-11-29 JLM		
	: Est Rev:E Re-Format 05-11-29 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101013	Saddle Billet
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s) \* no material in the computer  
 D6101-013 (7075-T7351)  
 Size 2.50" x 10.10" X 8.25" (Grain along 10.10")  
 Batch: ~~B340~~ B40 350 ml 08/08/02

2.0	HAAS3	HAAS CNC VERTICAL MACHINING #3
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Comment: HAAS CNC VERTICAL MACHINING #3

1-Machine as per folio D5951, Ensure Batch Number is entered

2-Machine Keyway

3-Deburr &amp; Tumble

SB/ml 08/08/04

PTU

3.0	QC1	INSPECT ALL DIM TO DIM SHEET
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Comment: INSPECT ALL DIM TO DIM SHEET

SB/ml 08/08/04

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

08.08.14  
Dr Julien Lavoque

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1




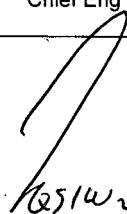
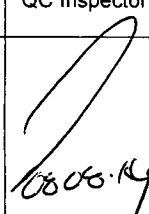
ml 08/08/15

14X

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D5951 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: <u>39793</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/08/03	2	1 part, the hole for the skid bolt was off of .020" 1 part, the hole for the skid bolt was off of .015" R.C. the hole for the flange was too big for the dowel pin in the last operation Dowel pin was wore out.	 651412	Parts acceptable per Test find ASS'y Replace dowel pins.	 08/08/03	 08/08/04	 651412	 08/08/04

NOTE: Date & initial all entries

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User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: OUTER FWD SADDLE

Job Number: 39793

Part Number: D5951

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



M 108523



14X

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

1:20  
320°F  
1:30

M-L 08/08/18

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



42



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-08-18

Y14

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

57491

SS 08/08/19 X14

9.0

QC21

FINAL INSPECTION/W/O RELEASE



08/08/20

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-08-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Vérification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 39793
<b>Description:</b> Outer Fwd Saddle		<b>Part Number:</b> D5951
<b>Inspection Dwg:</b> D5951	<b>Rev:</b> B	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.437	0.444		.444	.440	.440	.440		
B	1.745	1.755		1.754	1.750	1.750	1.750		
C	5.245	5.255		5.248	5.250	5.248	5.249		
D	6.995	7.005		7.002	7.000	7.000	7.000		
E	5.240	5.260		5.247	5.252	5.250	5.250		
F	4.745	4.755		4.748	4.750	4.750	4.751		
G	0.315	0.322		.322	.322	.322	.322		
H	1.522	1.532		1.527	1.527	1.525	1.526		
I	3.048	3.058		3.055	3.056	3.054	3.054		
J	4.575	4.585		4.579	4.578	4.577	4.580		
K	0.315	0.322		.322	.322	.322	.322		
L	0.495	0.505		.500	.500	.500	.500		
M	0.490	0.510		.501	.500	.502	.502		
N	1.615	1.635		1.628	1.632	1.626	1.632		
O	7.990	8.010		8.000	8.000	8.000	8.000		
P	2.240	2.260		2.251	2.258	2.255	2.255		
Q	0.307	0.312		.310	.310	.309	.309		
R	0.760	0.765		.760	.760	.761	.761		
S	0.490	0.510		.500	.500	.500	.500		
T	1.375	1.395		1.380	1.384	1.380	1.385		
U	2.000	2.020		2.000	2.003	2.001	2.006		
V									
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	Amf
Date:	08/08/03

Audited by:	J.L
Date:	08/08/05

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686	KJ/RF	
C	06.12.06	Dimensions A,G,K,L,N,P revised	KJ/EC	
D	07.06.15	Dimension G revised	KJ/JLM	
E	08.04.21	Dimension E revised	KJ/DD	

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 39793
<b>Description:</b> Outer Fwd Saddle		<b>Part Number:</b> D5951
<b>Inspection Dwg:</b> D5951	<b>Rev:</b> B	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	#5	#6	#7	#8		
A	0.437	0.444		.440	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	5.245	5.255		5.249	5.250	5.250	5.250		
D	6.995	7.005		7.000	7.000	7.000	7.000		
E	5.240	5.260		5.247	5.248	5.248	5.248		
F	4.745	4.755		4.751	4.751	4.750	4.750		
G	0.315	0.322		.322	.322	.322	.322		
H	1.522	1.532		1.527	1.527	1.527	1.527		
I	3.048	3.058		3.054	3.057	3.055	3.054		
J	4.575	4.585		4.581	4.578	4.578	4.578		
K	0.315	0.322		.322	.322	.322	.322		
L	0.495	0.505		.500	.500	.500	.500		
M	0.490	0.510		.502	.503	.503	.502		
N	1.615	1.635		1.633	1.634	1.633	1.633		
O	7.990	8.010		8.000	8.000	8.000	8.000		
P	2.240	2.260		2.258	2.258	2.258	2.258		
Q	0.307	0.312		.309	.309	.310	.309		
R	0.760	0.765		.760	.760	.761	.766		
S	0.490	0.510		.501	.500	.500	.500		
T	1.375	1.395		1.385	1.385	1.385	1.385		
U	2.000	2.020		2.006	2.006	2.005	2.005		
V									
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	ml
Date:	08/08/04

Audited by:	J.L
Date:	08/08/05

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686	KJ/RF	
C	06.12.06	Dimensions A,G,K,L,N,P revised	KJ/EC	
D	07.06.15	Dimension G revised	KJ/JLM	
E	08.04.21	Dimension E revised	KJ/DD	

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 39793
<b>Description:</b> Outer Fwd Saddle		<b>Part Number:</b> D5951
<b>Inspection Dwg:</b> D5951	<b>Rev:</b> B	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1 <sup>9</sup>	2 <sup>10</sup>	3 <sup>11</sup>	4 <sup>12</sup>		
A	0.437	0.444		.440	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	5.245	5.255		5.250	5.250	5.250	5.250		
D	6.995	7.005		7.000	7.000	7.000	7.000		
E	5.240	5.260		5.248	5.250	5.250	5.250		
F	4.745	4.755		4.750	4.750	4.750	4.750		
G	0.315	0.322		.322	.322	.322	.322		
H	1.522	1.532		1.527	1.526	1.526	1.526		
I	3.048	3.058		3.055	3.055	3.055	3.055		
J	4.575	4.585		4.578	4.578	4.578	4.578		
K	0.315	0.322		.322	.322	.322	.322		
L	0.495	0.505		.500	.500	.500	.500		
M	0.490	0.510		.502	.502	.501	.501		
N	1.615	1.635		1.633	1.633	1.633	1.633		
O	7.990	8.010		8.000	8.000	8.000	8.000		
P	2.240	2.260		2.259	2.259	2.259	2.259		
Q	0.307	0.312		.309	.309	.309	.309		
R	0.760	0.765		.760	.760	.760	.760		
S	0.490	0.510		.500	.500	.500	.500		
T	1.375	1.395		1.385	1.385	1.385	1.385		
U	2.000	2.020		2.006	2.006	2.005	2.005		
V									
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

<b>Measured by:</b> <i>ML</i>
<b>Date:</b> 08/08/04 / 08/08/05

<b>Audited by:</b> <i>JL</i>
<b>Date:</b> 08/08/05

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686	KJ/RF	
C	06.12.06	Dimensions A,G,K,L,N,P revised	KJ/EC	
D	07.06.15	Dimension G revised	KJ/JLM	
E	08.04.21	Dimension E revised	KJ/DD	

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 39793
<b>Description:</b> Outer Fwd Saddle		<b>Part Number:</b> D5951
<b>Inspection Dwg:</b> D5951	<b>Rev:</b> B	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.437	0.444		.440	.446				
B	1.745	1.755		1.750	1.756				
C	5.245	5.255		5.250	5.250				
D	6.995	7.005		7.000	7.000				
E	5.240	5.260		5.250	5.256				
F	4.745	4.755		4.750	4.756				
G	0.315	0.322		.322	.322				
H	1.522	1.532		1.527	1.527				
I	3.048	3.058		3.055	3.054				
J	4.575	4.585		4.579	4.579				
K	0.315	0.322		.322	.322				
L	0.495	0.505		.500	.500				
M	0.490	0.510		.501	.501				
N	1.615	1.635		1.630	1.636				
O	7.990	8.010		8.000	8.006				
P	2.240	2.260		2.250	2.250				
Q	0.307	0.312		.310	.316				
R	0.760	0.765		.760	.760				
S	0.490	0.510		.515	.520				
T	1.375	1.395		1.380	1.386				
U	2.000	2.020		2.000	2.000				
V									
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	<i>ml</i>
Date:	08/08/20

Audited by:	<i>[Signature]</i>
Date:	10.08.20

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686	KJ/RF	
C	06.12.06	Dimensions A,G,K,L,N,P revised	KJ/EC	
D	07.06.15	Dimension G revised	KJ/JLM	
E	08.04.21	Dimension E revised	KJ/DD	<i>[Signature]</i>

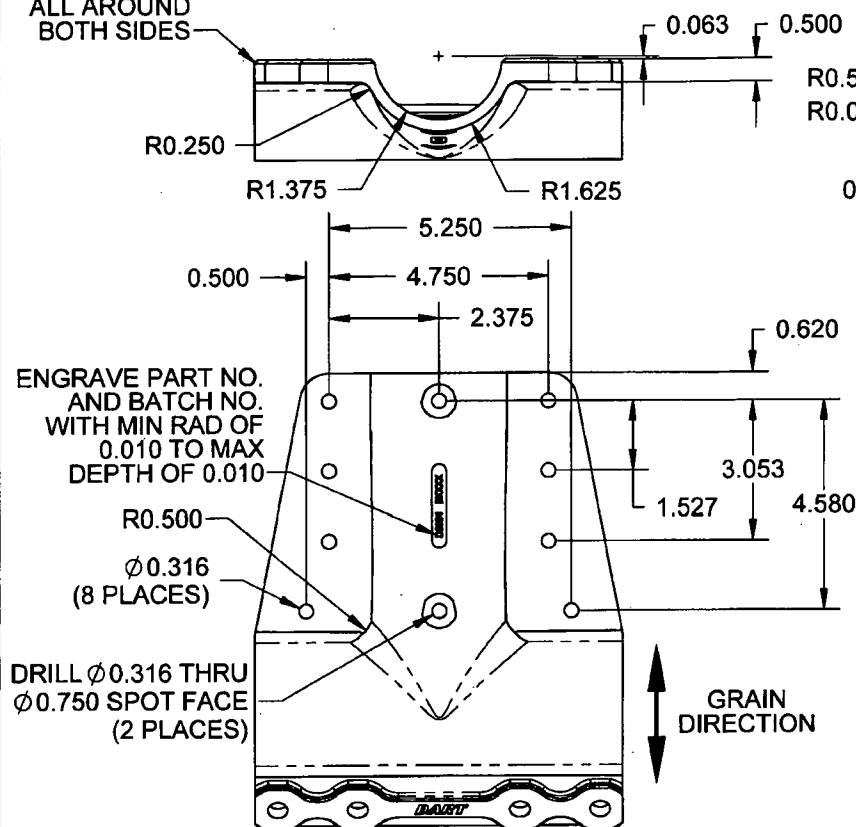


**DART**

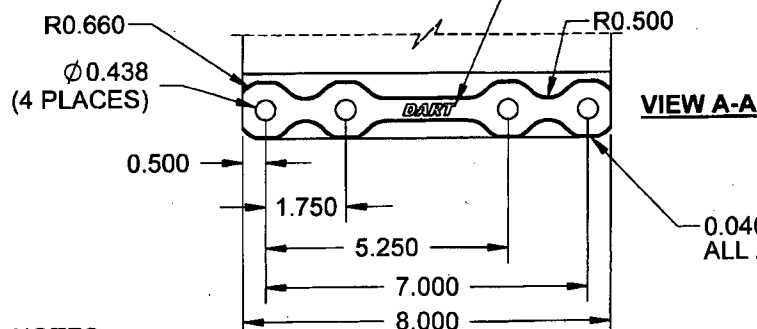
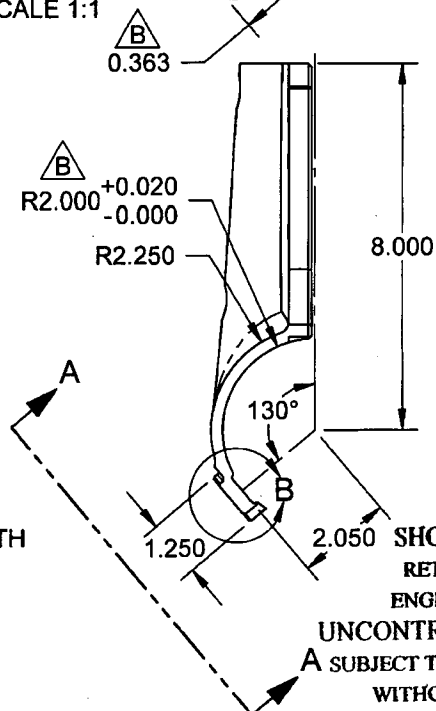
DESIGN <b>BW</b>	DRAWN BY <b>CB</b>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <b>LE</b>	APPROVED <b>[Signature]</b>	DRAWING NO. <b>D5951</b>	REV. B SHEET 1 OF 1
DATE <b>06.11.07</b>	TITLE <b>OUTER FWD SADDLE</b>		SCALE 1:4
REV A	DATE 97.05.06	DESCRIPTION NEW ISSUE	
B	06.11.07	INCORPORATE DEO 9102, DEO 9079; ADD 0.363 DIMENSION; Ø0.316 WAS Ø0.313; ADD TOLERANCE TO R2.000; ADD 0.363 DIM;	

CHAMFER  
0.075 X 45°  
ALL AROUND  
BOTH SIDES

RELEASED  
06.11.28



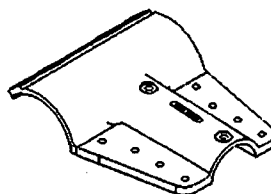
DETAIL B  
SCALE 1:1



**D5951 OUTER FWD SADDLE** NO. 39793

**NOTES:**

- 1) MATERIAL: ALUMINUM 7075-T7351 PER QQ-A-250/12  
(MAKE FROM D6101-013 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020



**ISOMETRIC VIEW**  
SCALE 1:8

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